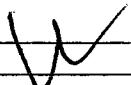
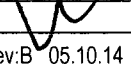











Date: Wednesday, 15/08/2007 4:03:10 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY HIGH SKID RH
Job Number	: 33955		
Estimate Number	: 10720		
P.C. Number	: N/A	Part Number	: D350591214
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: D3078 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 31616	Material	: N/A
Written By	: 	Due Date	: 05/09/2007 Qty: 5 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			(8) KS 07.08.09
Comment: DOCUMENT CONTROL		En 07/09/12	
Photocopy bluefile and type labels as per PPP D350-591-214 CHG002			
2.0	D2622120C	Extrusion	
			(PTU)
Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.5000 Each(s)		331934=1 PE 07-09-12	
Pick:		Q1334016 a.m 07.09-12	
	Qty Part Number Description Batch	5	
	.5 D2622-120 Extrusion	B2960760	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078		a.m 07.09.12 5	
2-Drill extrusion as per Dwg D3078 using Jig DT868Q for rivets.		a.m 07.09.12 5	
3-Deburr		a.m 07.09.12 5	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			Counts
Comment: INSPECT WORK TO CURRENT STEP		En 07/09/13 (45)	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____














QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0709.12	2.0	1 step was found with a "BIG" dent on the top aft section.	Q51012	Scrap: replace / Place aside for possible tooling weld jig. I.D. the scrap step as scrap: w/ B# 31984	07.09.13	Ep 07.09.13	Q51012	0709.12.

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:03:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH	
Job Number: 33955		Part Number: D350591214	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
5.0	D30671	End Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
1 D3067-1 End Plate <u>334312</u>			
<i>PE 01-09-12</i> 5			
6.0	D30631	Support	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
1 D3063-1 Support <u>330892</u>			
<i>PE 07-09-12</i> 5			
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
1-Bevel end for welding FWD ONLY			
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078			
A/R Aluminum Rod <u>M103794</u>			
<u>M104721</u>			
3-Grind End Plate flush			
<i>PE 07-09-12</i> 5			
<i>PE 07-09-13</i> 5			
8.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION			
9.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
<i>En 07/09/13</i> (SPH) 5			
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1			
Chemical Conversion Coat as per QSI 005 4.1			
<i>G.m 07-09-13</i> 5			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector









Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH	
Job Number: 33955		Part Number: D350591214	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		 (5X) 07/09/17	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			
12.0	D3065041	Step Leg Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
1 D3065-041 Step Leg Assy M705 B33510 a.m 07.09.17 5			
13.0	D30661	Spacer	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
2 D3066-1 Spacer B32857 a.m 07.09.17 5			
14.0	MS20600AD4W4	Rivets	
			
Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
16 MS20600AD4W4 Rivet M105408 a.m 07.09.17 5			
15.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
Rivet Leg Assembly as per Dwg D3078. a.m 07.09.17 5			
16.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
17.0	D30671	End Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Pick:			
Qty Part Number Description Batch			
1 D3067-1 End Plate B34312 a.m 07.09.18 5			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:03:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 33955

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M103794

4-Grind End Plate flush

d.m 07.09.18

PE 07.09.18

PE 07.09.18

PE 07.09.18

5
5
5
5

19.0	QC9	VISUAL WELDING INSPECTION
------	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

PE 07/09/19 (5)

20.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PE 07/09/19 (X5) RH

21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

MD 07.09.19 (X5)

22.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

M-PE 07/09/19 (X5)

23.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

M105386 MD 07.09.19 (5)

24.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	-----------------------------------------



Comment: Inspect Powder Coat and Wing Walk

PE 07/09/20 (X5) RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:03:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 33955

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

B 30993

27.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

B 33697

5X

B 32163

4X

28.0

D2732

Rubber Extrusion



Comment: Qty.: 0.5000 f(s)/Unit Total: 2.5000 f(s)

Rubber Extrusion

4 X 3"

Batch:

B 26972

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 3.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

B 25656

600 COUPE À 400

30.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M 104021

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:03:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 33955

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN411A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) *per Blue file*

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

M102280

32.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Batch:

M104746 11X

M105426 9X

33.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M105442

34.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M104746

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M104936

3209-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-09-20	31	permanent change	h	07-09-20			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:03:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 33955

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



(P102)

Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M104248

6-7/9/12 (5)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 05/09/12

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev:

6-7/9/12 (5)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5
12/07/10/12

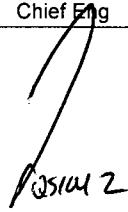

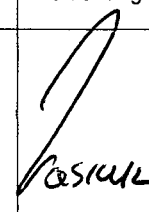
Job Completion



u 17/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/20	2	missing or nut in one loc R.C. human error		ADD missing nut to loc.		En 07/09/20		En 07/09/20

NOTE: Date & initial all entries



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CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *CP*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 33955

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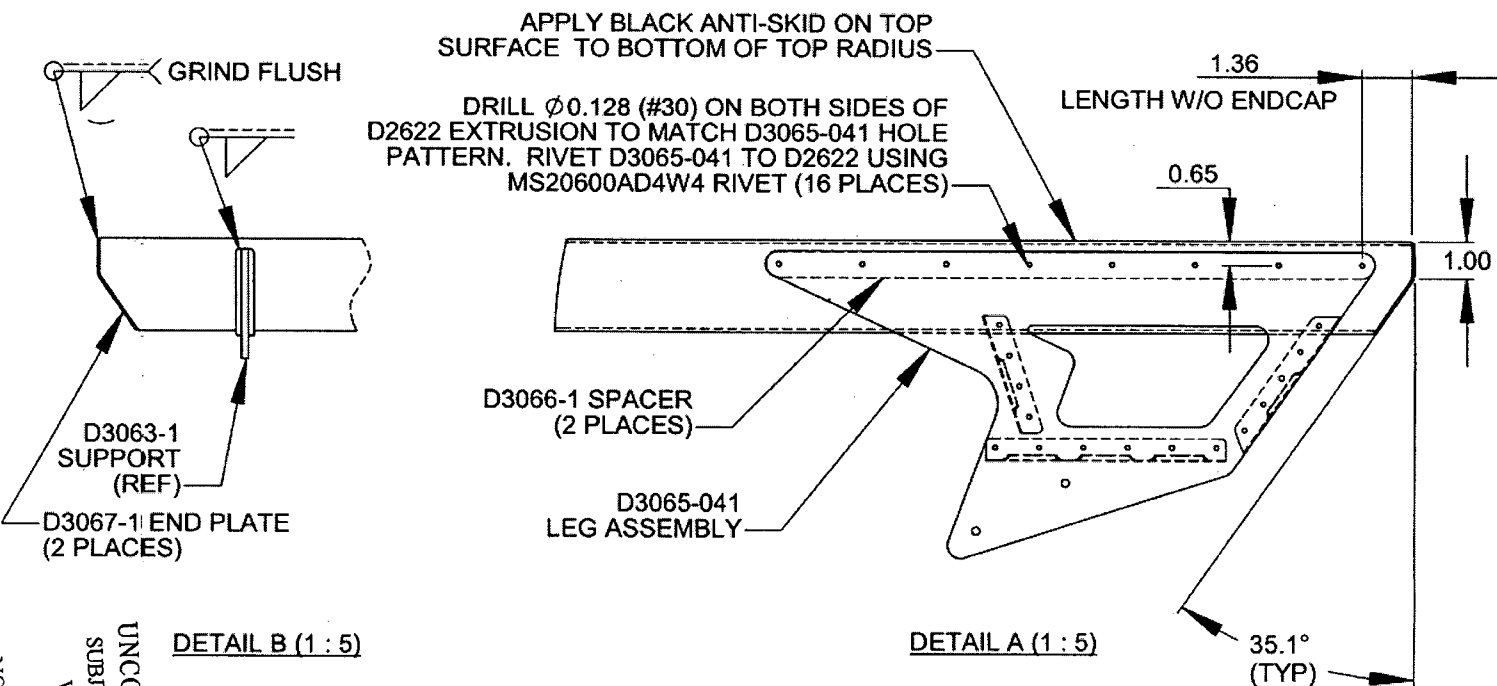
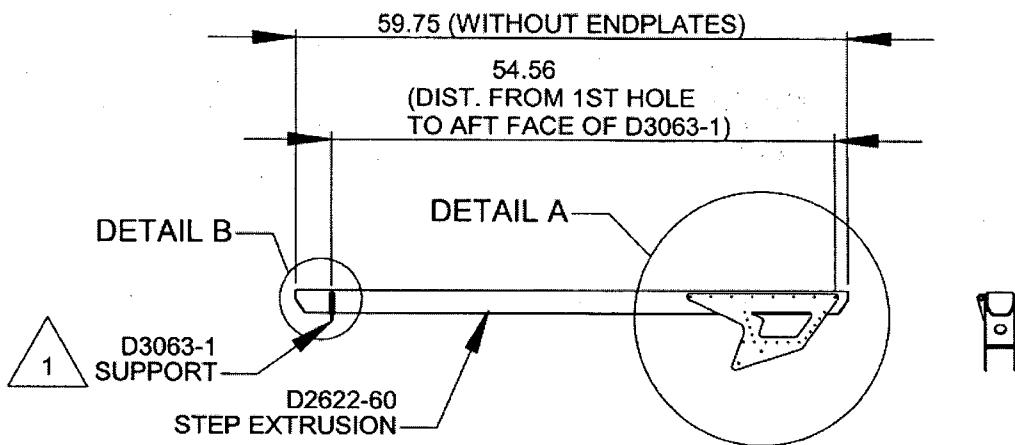
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DART



DESIGN	SP	DRAWN BY	SP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	SP	APPROVED	SP	REV. A
DATE	02.09.11	TITLE	D3078	SHEET 2 OF 2
			STEP ASSEMBLY, HI SHORT	SCALE 1:20

RELEASED
02.09.2004



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